

Date: Tuesday, 22/04/2008 3:53:14 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: SADDLE, INBOARD, LS, 206		
Job Number	38751				Part Number	: D26661
Estimate Number	10820				Drawing Number	: D2666 REV. D
P.O. Number					Project Number	: N/A
This Issue	22/04/2008	S.O. No. :				
Prsht Rev.	NC				Drawing Revision	: D
First Issue	/ /	Type	MACHINED PARTS			
Previous Run	37332				Material	:
Written By	:				Due Date	: 10/05/2008
Checked & Approved By	:	JLP 08.4.23			Qty:	12
Comment	Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC			Um:	Each	
	Est Rev:D As per Rev D 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length <i>DIP 08/06/21</i> Batch No: <i>34872</i>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	 <i>Pb</i>
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr <i>DIP 08/06/21</i>	<i>12</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	 <i>12</i>
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <i>DIP 08/06/21</i>	<i>12</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>12</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DIP 08/06/21</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		o					

Part No: D2666-1 PAR #: N/A Fault Category: Prod/Machined Part NCR: Yes No DQA: D Date: 08/07/03
 D206-642- QA: N/C Closed: D Date: 08/07/03

NCR: 38751		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/23	2.0	One part has a chamber on the base of the spindle where it meets with the skid Luke. on the ^{inside} _{INSIDE}	GP 08.06.23 PSI 042	Part ACCEPTABLE	DJP 08/06/23 PSI 042	C 08/06/23	GP 08.06.23 PSI 042	C 08/06/23
		R.C. operator did not place the bitter in the correct orientation after sylinder						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 38751

Part Number: D26661

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



S 00106104 x12

Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



12X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF

08/06/24

7.0 POWDER COATING POWDER COATING



m10792S



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.1

MF/921 08/07/03 P.T.O.

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



S 08107102 x12

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



10X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 426

8/1/2

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/03 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/02	7.0	Start Time <u>7:40</u> Oven temp <u>320</u> Finish time <u>8:10</u>	Xh	08/07/02 12			<u>08/07/02</u>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

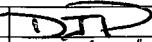
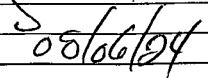
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

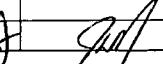
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38751
Description: 206 Saddle, Inboard, Left side		Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.118	0.123	0.122	0.122		
B	0.100	0.140		0.120	0.120	0.121	0.121		
C	2.470	2.510		2.500	2.501	2.501	2.501		
D	0.100	0.180		0.135	0.135	0.135	0.135		
E	0.210	0.230		0.220	0.230	0.220	0.221		
F	1.313	1.343		1.323	1.3345	1.322	1.323		
G	0.240	0.260		0.248	0.259	0.247	0.247		
H	0.615	0.685		0.645	0.640	0.645	0.645		
I	1.125	1.145		1.136	1.1365	1.1355	1.1365		
J	0.990	1.010		0.998	0.998	0.999	0.998		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.113	0.113	0.113	0.113		
N	1.565	1.585		1.571	1.571	1.571	1.571		
O	5.990	6.010		5.999	5.999	5.999	5.999		
P	1.245	1.255		1.251	1.249	1.250	1.250		
Q	2.495	2.505		2.502	2.500	2.499	2.500		
R	0.490	0.510		0.4975	0.499	0.499	0.500		
S	0.313	0.318		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.498	2.500	2.498	2.500		
U	1.357	1.367		1.360	1.362	1.362	1.363		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.5445	0.5465	0.5465	0.5465		
X	1.674	1.684		1.678	1.679	1.679	1.678		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:		Audited by:	
Date:	08/06/21	Date:	08/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM 	

DART AEROSPACE LTD		Work Order: 38751
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		0.122	0.122	0.124	0.124		
B	0.100	0.140		0.122	0.121	0.121	0.122		
C	2.470	2.510		2.501	2.501	2.500	2.499		
D	0.100	0.180		0.135	0.135	0.140	0.140		
E	0.210	0.230		0.222	0.221	0.221	0.221		
F	1.313	1.343		1.323	1.323	1.322	1.322		
G	0.240	0.260		0.247	0.248	0.248	0.248		
H	0.615	0.685		0.600	0.600	0.615	0.600		
I	1.125	1.145		1.137	1.1365	1.1360	1.137		
J	0.990	1.010		0.998	0.998	0.998	0.998		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.113	0.113	0.113	0.113		
N	1.565	1.585		1.572	1.572	1.571	1.572		
O	5.990	6.010		5.999	5.999	5.999	6.000		
P	1.245	1.255		1.250	1.249	1.249	1.249		
Q	2.495	2.505		2.500	2.499	2.500	2.498		
R	0.490	0.510		0.501	0.501	0.502	0.500		
S	0.313	0.318		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.363	1.363		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.546	0.5465	0.5455	0.545		
X	1.674	1.684		1.679	1.679	1.678	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

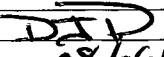
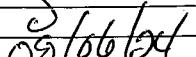
Measured by:	DT	Audited by:	
Date:	08/06/22	Date:	08/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	38751
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.100	0.140		0.123	0.124	0.122	0.122		
B	0.100	0.140		0.121	0.121	0.120	0.120		
C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		0.140	0.140	0.140	0.140		
E	0.210	0.230		0.221	0.220	0.221	0.221		
F	1.313	1.343		1.321	1.322	1.322	1.322		
G	0.240	0.260		0.248	0.247	0.249	0.249		
H	0.615	0.685		0.660	0.660	0.660	0.660		
I	1.125	1.145		1.1365	1.1365	1.1365	1.1365		
J	0.990	1.010		0.998	0.998	0.998	0.998		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.510	0.515		0.511	0.511	0.511	0.511		
M	0.100	0.120		0.112	0.113	0.113	0.113		
N	1.565	1.585		1.571	1.571	1.570	1.571		
O	5.990	6.010		5.999	6.000	6.000	6.000		
P	1.245	1.255		1.2485	1.249	1.250	1.250		
Q	2.495	2.505		2.500	2.501	2.501	2.501		
R	0.490	0.510		0.500	0.502	0.501	0.502		
S	0.313	0.318		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.363	1.362	1.362		
V	0.315	0.322		0.322	0.322	0.322	0.322		
W	0.540	0.560		0.54465	0.545	0.5455	0.546		
X	1.674	1.684		1.675	1.678	1.678	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:		Audited by:	
Date:	08/06/23	Date:	08/06/23

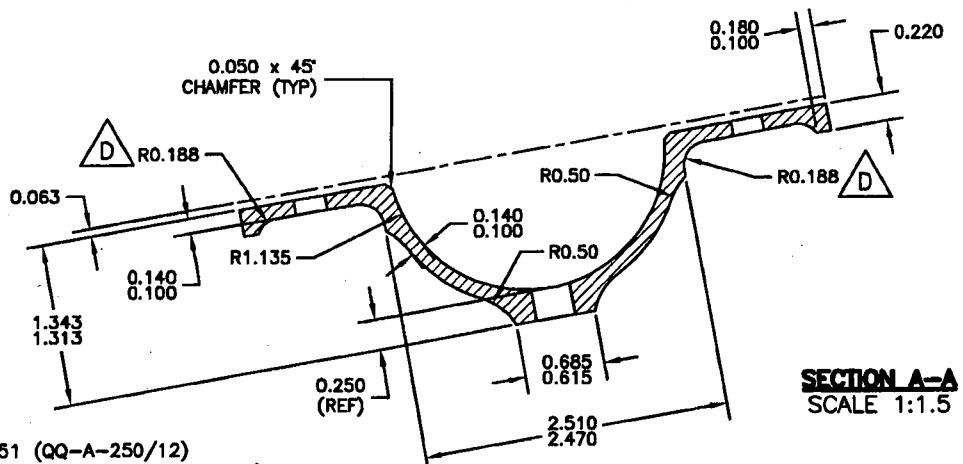
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B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
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E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM 	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2666 REV. D SHEET 1 OF 1
DATE		TITLE SCALE
06.11.08		SADDLE FWD INSIDE HIGH 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; ϕ 0.316 WAS ϕ 0.313

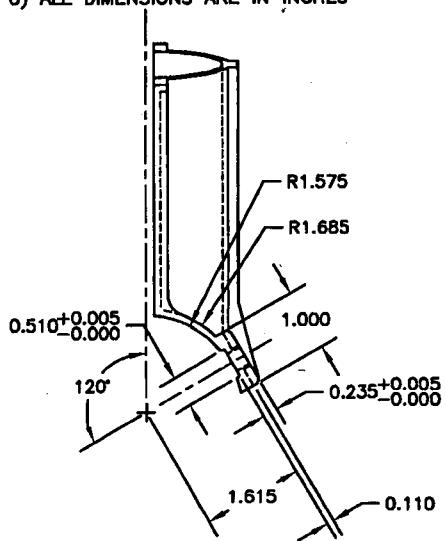
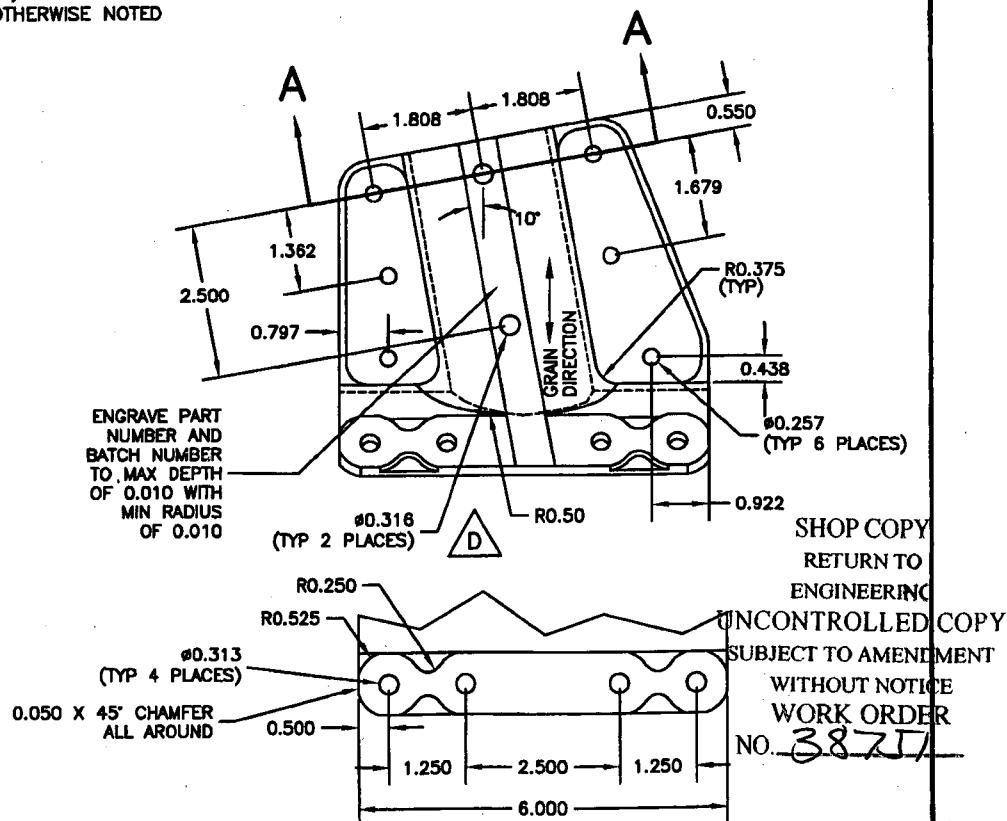
RELEASED

07.02.12



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

D2666-1 SADDLE FWD INSIDE HIGH

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